



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-630-032
Job Sheet 190421



Part No: D412-630-032

Job Qty: 3 pcs

Part Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 13424*

Note: DWG IIN D412-630 REV O SHEET 24, D3462 REV C IPP REV. A 05.11.21 NEW ISSUE EC IPP REV. B 05.12.19 updated pick list EC IPP REV.C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D 10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01 removed qty1 an310-4 EC verified by: DD IPP REV: F 16.06.23 AS PER IIN REV.O DD VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	3 pcs	3/12/19		0.00	0.93	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		DAS
							Small Fab - 4		36
							Small Fab - 5		9-88
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	3 pcs	3/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 1-1 - Pick Kit - B4B	3 pcs	3/12/19		0.00	0.00	Packaging 1 - 1 - B4B		
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		
							Packaging 1 - 4 - B4B		
							Packaging 1 - 5 - B4B		

Plex 2/8/19 10:41 AM Dart.lajeunesse.marie

				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	MAR 21 2019
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
140 QC 4	3 pcs	3/12/19	0.00 0.00	QC 4 - 26	
				QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	
				QC 4 - 69	MAR 21 2019
				QC 4 - 9	
				QC 4 - 46	
150 Packaging 3-1 - Stock - B4B	3 pcs	3/12/19	0.00 0.00	Packaging 3 - 1 - B4B	MAR 21 2019
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
155 DC - 1 - B4B	3 pcs	3/12/19	0.00 0.00	DC - 1 - B4B	21
				DC - 2 - B4B	9-88 MAR 2 1 2 19
160 QC 21 - FG	3 pcs	3/12/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-88 MAR 2 1 20 9

Part Op 110 - (Small Fab) Assemble as per IIN D412-630 ****ensure tension to retract step is 11 to 18 lbs before installing
 Descriptions: lockwire.**** A/R MS20995C41 batch: 4131379

120 - (QC5- Inspect part completeness to step on W/O) ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. ENSURE STEP IS A RH: _____

130 - (Pick Kit)

140 - (QC4- 100% Inspect kits for completeness) VERIFY ORIENTATION OF D3462/D3463: _____

150 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D412-630-032 ENSURE STEP IS A RH: _____ Location;FG034

155 - (Document Control) Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004

160 - (QC21- Final Inspection - Work Order Release)

DART
AEROSPACE

Container No: S164384

Part: D412-630-032

Job No: 190421

Serial No/Batch: S164384

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: TC STC SH96-69 Issue 7 Rev A-2 STC SR005951

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-8200
Email: sales@dartaero.com
www.dartaerospace.com

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310-4 ³⁵ 331	Nut	3 Ea (1 ea)	110-Small Fab - 1	5082904
AN310-7 ³³¹	Nut	3 Ea (1 ea)	110-Small Fab - 1	Fm120124
AN4C14 ⁰⁴⁵⁰⁰²	Bolt	3 Ea (1 ea)	110-Small Fab - 1	5156687
AN4CH3 ³⁴⁶	Bolt	6 Ea (2 ea)	110-Small Fab - 1	5158312
D3443-041 ³⁵	Strut Weldment Assembly	3 pcs (1 ea)	110-Small Fab - 1	5160027
D3443-043 ³⁵	Strut Weldment Assembly	3 pcs (1 ea)	110-Small Fab - 1	5160631
D3443-9 ³⁵	Pin	6 pcs (2 ea)	110-Small Fab - 1	5159088
D3454-7 ³⁶	Bushing	6 pcs (2 ea)	110-Small Fab - 1	5159293
D3455-1 ³⁶	Spacer	6 pcs (2 ea)	110-Small Fab - 1	5159397
D3463-042	Step Weldment Assembly	3 pcs (1 ea)	110-Small Fab - 1	5159855
D3465-1 ³⁷	Washer	3 pcs (1 ea)	110-Small Fab - 1	F149356
MS24665-227 ²⁸⁹	Cotter Pin	3 Ea (1 ea)	110-Small Fab - 1	Fm135671
MS24665-302 ²⁸⁸	Cotter Pin	3 Ea (1 ea)	110-Small Fab - 1	5156979
AN310-4	Nut	3 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5082904
AN310-5	Nut	6 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	506246x15101837x5
AN3C5A	Bolt	9 Ea (3 ea)	130-Packaging 1-1 - Pick Kit - B4B	5082907
AN44-C12	Eye Bolt	3 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm135885x1
AN4C15	BOLT	3 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	519859
AN5C11	Bolt	3 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm135722
AN5C15	Bolt	3 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm138336
D3454-1	Bushing	3 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5077631
D3454-3	Bushing	6 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5142047
D3454-5	Bushing	6 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5011088x4 F149326x2
D3455-1	Spacer	12 pcs (4 ea)	130-Packaging 1-1 - Pick Kit - B4B	5159391
D3455-3	Spacer	6 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	F149455
D3462-042	Bracket Assembly	3 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5119107
D3672-5	Washer, Phenolic	3 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	F153354
MS21043-3	Nut	9 Ea (3 ea)	130-Packaging 1-1 - Pick Kit - B4B	5149144
MS24665-227	Cotter Pin	6 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm135671
MS24665-229	Cotter Pin	6 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm135671-1
NAS1149C0363R	Washer	21 Ea (7 ea)	130-Packaging 1-1 - Pick Kit - B4B	5132615
NAS1149C0563R	Washer	3 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5060989
AN3C6A	Bolt	3 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5049451

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN310-4	3	118	0
	AN310-7	3	10	0
	AN4C14	3	11	0
	AN4CH3	6	1	0
	D3443-041	3	3	0
	D3443-043	3	3	0
	D3443-9	6	3	0
	D3454-7	6	2	0
	D3455-1	6	13	0
	D3463-042	3	2	0
	D3465-1	3	20	0
	MS24665-227	3	53	0
	MS24665-302	3	10	0
130-Packaging 1-1 - Pick Kit - B4B	AN310-4	3	118	0
	AN310-5	6	46	0
	AN3C5A	9	1,119	0
	AN3C6A	3	172	0
	AN44-C12	3	11	0
	AN4C15	3	49	0
	AN5C11	3	9	0
	AN5C15	3	7	0
	D3454-1	3	15	0
	D3454-3	6	14	0
	D3454-5	6	27	0
	D3455-1	12	13	0
	D3455-3	6	51	0
	D3462-042	3	9	0
	D3672-5	3	521	0
	MS21043-3	9	1,382	0
	MS24665-227	6	53	0
	MS24665-229	6	132	0
	NAS1149C0363R	21	645	0
	NAS1149C0563R	3	120	0
Part Specifications				
Specifications could not be found.				

Plex 2/8/19 10:41 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			